

Work Order ID 140632 -1

140632

Tuesday, January 12, 2016 11:17:20 AM

Page 1

Item ID: D120-637-011

Accept

N9000040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Heli-Access Step™, LH

Start Date: 1/12/2016 Start Qty: 2.00

2

slip

Cust Item ID:

Required Date: 1/12/2016 Req'd Qty: 2.00

2

Customer:

Reference: RE-INSPECT

Approvals: Process Plan: amc

Date: 16-1-12

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D120-637	E

150 0.00

150

QC

Quality Control

Memo

0.00

PULL FROM STOCK D120-637-011 X 2 B14694

RE-INSPECT D120-637-011 x 2 b14694

MLJ JAN 13 2016
(2)

160

Identify as per dwg & Stock Location: F9082 0.00

160

Packaging

Memo

0.00

Packaging

2X DAS 28 9-89 27 9-89 FEB 03 2016

170

QC21- Final Inspection - Work Order Release 0.00

170

QC

Quality Control

Memo

0.00

MLJ FEB 05 2016

MLJ FEB 05 2016

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐							
Date :		Step #:		QTY Effective :				MRB (QS1042) Approval			
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval			
Root Cause		FAULT CATEGORY									
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐	Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐	Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐	Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐	Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐
Past Expiry Date ☐	Manufacturing Process ☐	OTHER :									
Misidentified ☐	Past Due ☐										

Checklist Print

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Page 1

Work Order ID: 140632

140632

Parent Item: D120-637-011

D120-637-011

Parent Item Name: Heli-Access Step™, LH

Start Date: 1/12/2016

Required Date: 1/12/2016

Start Qty: 2.00

Required Qty: 2.00

Comments:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D120-637-011

Manufactured No

Each 0.0000

2

D120-637-011

Heli-Access Step™, LH

2 x 14694 mf

16-1-12

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐							
Date: _____		Step #: _____		QTY Effective: _____				MRB (QS1042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval			
Description Work Order Deviation				Disposition							
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐		☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due		☐ Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter		FAULT CATEGORY ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes		☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center		☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence	
				OTHER : _____							

List Lots

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Criteria : Item ID: d120-637-011 All Locations All Warehouses All Quantity

Item ID Item Name	Warehouse ID Location ID	Lot Number	Last Trans Date	Lot Qty	Shelf Life Dt Lot Code	Type Code	Comments
D120-637-011 Heli-Access Step™, LH	Premier	14694	9/18/2009	2.0000	QC21	CHG003	
	Mezz						
	Premier	14917	7/10/2015	5.0000	QC21	CHG003	
	Mezz						
Total:				7.0000			

127892

#140630

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																														
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval																																																										
Description Work Order Deviation				Disposition																																																														
Root Cause		FAULT CATEGORY																																																																
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Misidentified ☐	Past Due ☐																																																																	

DART

REFERENCE ONLY

DESIGN KE	DRAWN BY KE	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED MEY	APPROVED BW	DRAWING NO. D120-637	REV. E SHEET 1 OF 6
DATE 97.09.24		TITLE EC120 HELI-ACCESS-STEP	SCALE NTS
A	96.10.23	ORIGINAL ISSUE	
B	97.02.17	CHANGE FRONT MOUNT	
C	97.05.01	CHANGE AFT MOUNT TO CLEAR FAIRING	
D	97.05.19	CHANGE FRONT MOUNT	
E	97.09.24	CHANGE STEP LENGTH	

Qty -011	Qty -012	Qty -041	Qty -042	Part Number	Description
X				D120-637-011	STEP INSTALLATION LH
	X			D120-637-012	STEP INSTALLATION RH
1		X		D2610-041	STEP ASSEMBLY LH
	1		X	D2610-042	STEP ASSEMBLY RH
8 ✓	8			D2274	RADIUS BLOCK
2 ✓	2			D2615-1	MOUNTING LUG
1 ✓				D2616-1	MOUNTING LUG (LH)
	1			D2616-2	MOUNTING LUG (RH)
1 ✓	1			D2617-3	BUSHING
2 ✓	2			D2617-5	SPACER
2 ✓	2			D2618	BUSHING
1 ✓	1			D2619-041	COVER
		1	1	D2674-3	NUT PLATE
		1		D2678-041	STEP WELDMENT LH
			1	D2678-042	STEP WELDMENT RH
2 ✓	2			D2679	MOUNTING CLAMP
2 ✓	2			D2681	CLAMP
		1	1	D2682-041	SUPPORT PLATE
		1	1	D2683-041	FRONT MOUNT PLATE
4 ✓	4			AN4-11A	BOLT
1 ✓	1			AN4-14A	BOLT
2 ✓	2			AN4-16A	BOLT
2 ✓	2			AN5-36A	BOLT
3 ✓	3			AN526C832R8	SCREW
3 ✓	3			AN960JD8	WASHER
		2	2	AN960JD10L	WASHER
14 ✓	14			AN960JD416	WASHER
4 ✓	4			AN960JD516	WASHER
		2	2	MS20426AD3-5	RIVET
7 ✓	7			MS21042L4	NUT (OR MS21042-4)
2 ✓	2			MS21042L5	NUT (OR MS21042-5)
		2	2	MS24693-S272	SCREW (OR MS24693-C272)
		2	2	MS27039-1-09	SCREW
		5	5	M7885/3-4-3	RIVET (OR CR3212-4-3)